

Work Order ID 84476

84476

Page 1

May-15-12 1:02:44 PM

Item ID: D206-642-411

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH

Start Date: 5/14/12 Start Qty: 1.00

1


Cust Item ID:

Required Date: 5/14/12 Req'd Qty: 1.00

1

Customer:

Reference: rework - ECN09-531

Approvals: Process Plan: 

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D206-642

O

0.00

100

100

DOCUMENT CONTROL

SP

0.00

DC

Memo

Document Control

Photocopy bluefile and create labels per PPP D206-642-411 CHG006

Srlocho

Derms 12-6-7

Work Order ID 84476***84476***

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Item ID: D206-642-411

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Skidtube LH

Stop ***NS2***Start Date: 5/14/12 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/14/12 Req'd Qty: 1.00 ***1***

Customer:

Reference: rework - ECN09-531

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

101

0.00

101

HandFinish

Hand Finishing

Memo

PULL FROM HK:

1 X D206-642-411 B38777

UPDATE TO CHG006 PER ECN08-538 & 09-531 DSI9421/9440

REMOVE WEARPLATES:

6 X D2648-3 B34591

1 X D2656-15 B34596

1 X D2656-23 B34597

1 X D2656-37 B34510

1 X D3429-1 B34609

RETURN TO STK

DISCARD HARDWARE

ADD:

6 X D3537-1 B _____

1 X D3537-3 B _____

1 X D3535-15 B _____

1 X D3536-15 B _____

1 X D3535-23 B _____

1 X D3536-23 B _____

1 X D3535-37 B _____

1 X D3536-37 B _____

60 X MS27039C1-08 B _____

60 X AN960C10L (NAS1149C0332R)

B _____

1 ϕ B212-0-4

DART			
TRANSPORT CANADA APPROVAL # 09-89			
P/N	D206-642-411	CHG	CHG004
DESC	Skidtube LH High	STC	SH98-4
LOT	B38777	STC	SA00475SE
MODEL	Bell 206L/L1/L3/L4	STC	
US PATENT # 5735484			
CANADA FOREIGN PATENTS PENDING			
MADE IN CANADA			

Work Order ID 84476***84476***

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Item ID: D206-642-411

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Skidtube LH

Stop ***NS2***

Start Date: 5/14/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/14/12 Req'd Qty: 1.00

1

Customer:

Reference: rework - ECN09-531

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

105

QC5- Inspect part completeness to step on W/O

0.00

105

QC

Memo

0.00

Quality Control

5/16/12

Work Order ID 84476

84476

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Item ID: D206-642-411

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube LH

Start Date: 5/14/12 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 5/14/12 Req'd Qty: 1.00 *1*

Customer:

Reference: rework - ECN09-531

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

Pick Kit

0.00

110

Packaging

Packaging

Memo

0.00

REMOVE FROM KIT TO UPDATE TO CHG006:

1 X D2707-043(OR D2968-043)-SCRAP

1 X AN960JD1016 B 3519

1 X AN970-4 B 107242

1 X MS21043-4 B 106051

1 X AN4-5A B 106242

1 X AN960JD416 B 107321

1 X D2655 B 34613

RETURN TO STK

ADD TO KIT:

1 X D3407-043 B

1 X D3456-1 B 81876

2 X D3457-1 B 81977

1 X MS21043-4 B 921162

1 X AN4C5A B 119017

1 X AN960C416 B 119097

1 X D3413-1 B 82307

12/6/74

Work Order ID 84476

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Item ID: D206-642-411

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube LH

Start Date: 5/14/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/14/12 Req'd Qty: 1.00

1

Customer:

Reference: rework - ECN09-531

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Quality Control

insure SADDY Arc correct and
Memo
in Box

0.00

S. D. 12/6/12

130

Packaging

0.00

130

Packaging

Packaging

Memo

0.00

REPACKAGE PER PPP USING NEW B/N
NEW LABELS AND PAPERWORK REQ'D
Identify and pack for shipping as per PPP D206-642-411
Location: *SD*
PPP Rev: *F*

12/6/2012

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Quality Control

Memo

0.00

12/6/2012

MF
12-06-21

Picklist Print

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Page 1

Work Order ID: 84476

Parent Item: D206-642-411

Parent Item Name: Skidtube LH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:K05.10.11Revised picklist per CHG004KJ/CP/JLM
IPP Rev:L 07-12-04 ECN 1080p DD verified by:ec
IPP rev:M 08-09-29 as per DSI9421 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-5A Bolt		Purchased	No				Each	974.0000		-1		M106242	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST355		974							
				120562		974							
AN4C5A BOLT		Purchased	No				Each	199.0000					
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST355		199							
				112243		139							
				119017		60							
S AN960C416 washer	NAS1149C0463R	Purchased	No				Each	0.0000		1		M119097	
AN960JD1016 Washer	NAS1149C1063R	Purchased	No				Each	369.0000		-1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz		369							
				5519		369							
AN960JD416 Washer	NAS1149D0463J	Purchased	No				Each	30.0000		-1		M107321	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST351		30							
				116289		10							
				119097		20							

D2968-043

B37380

Picklist Print

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Work Order ID: 84476

Parent Item: D206-642-411

Parent Item Name: Skidtube LH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

AN970-4 Purchased No Each 203.0000
Washer

-1 1072428

Location	Loc Qty	Loc Code
ST344	203	
115936	11	
120308	3	
120644	30	
121285	159	

D206-642-411 Manufactured No Each 1.0000
Skidtube LH

1 3844768

Location	Loc Qty	Loc Code
FG081	1	
78486	1	

D2648-3 Manufactured No Each 9.0000
Wearpad

-6 BR 126-4

Location	Loc Qty	Loc Code
ST 34591	-10	
81513	9	
ST237A	19	

6

D2655 Manufactured No Each 30.0000
Ring

-1 7346138

Location	Loc Qty	Loc Code
ST464	30	
44295	15	
45738	15	

D2656-15 Manufactured No Each 6.0000
Wearshoe

-1 BR 126-4

Location	Loc Qty	Loc Code
FP 34596	5	
83601	5	
Mezz	1	
51455	1	

1

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Shop Packet Print

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Picklist Print

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Work Order ID: 84476

Parent Item: D206-642-411

Parent Item Name: Skidtube LH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

D2656-23 Manufactured No Each 9.0000
Wearshoe

-1

BR 12-6-4

Location	Loc Qty	Loc Code
Mezz 34597	9	
43407	2	
51468	7	

1

D2656-37 Manufactured No Each 21.0000
Wearshoe

-1

BR 12-6-4

Location	Loc Qty	Loc Code
Mezz	21	
34510 ✓	2	
44550	7	
46497	1	
53019	11	

1

D3407-043 Manufactured No Each 14.0000
Tow Ring

-1

BR 83325

Location	Loc Qty	Loc Code
ST420	1	
79232	1	
ST463	13	
68339	2	
77504	10	
78841	1	

D3413-1 Manufactured No Each 73.0000
Ring

1

12/6/78

Location	Loc Qty	Loc Code
ST420	4	
79233	4	
ST464	69	
76754	1	
80224	7	
83307	41	
83867	20	

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Work Order ID: 84476

Parent Item: D206-642-411

Parent Item Name: Skidtube LH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

D3429-1 Manufactured No Each 16.0000
Wearpad

-1

126-4.

Location	Loc Qty	Loc Code
FP002 34609.	16	
40438	2	
43706	1	
44579	12	
65692	1	

1

D3456-1 Manufactured No Each 168.0000
Washer

1

Location	Loc Qty	Loc Code
FG	7	
25701	7	
ST044	161	
80252	1	
81876	60	
83584	100	

1

2

D3457-1 Manufactured No Each 35.0000
Washer

Location	Loc Qty	Loc Code
FG	10	
32409	10	
ST044	25	
67779	1	
81977	24	

2

1

BR 12-6-4.

D3535-15 Manufactured No Each 17.0000
Wearshoe

Location	Loc Qty	Loc Code
FP001	17	
80328	4	
81354	13	

1

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Shop Packet Print

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Picklist Print

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Page 5

Work Order ID: 84476

Parent Item: D206-642-411

Parent Item Name: Skidtube LH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

D3535-23 Manufactured No Each 22.0000 1 BR 12-6-4
Wearshoe

Location	Loc Qty	Loc Code
FP001	22	
81355	2	
83375 ✓	20	

D3535-37 * Manufactured No Each 4.0000 1 BR 12-6-4
Wearshoe

Location	Loc Qty	Loc Code
FP001 84807.	4	
71668	4	

D3536-15 Manufactured No Each 20.0000 1 BR 12-6-4
Gasket

Location	Loc Qty	Loc Code
FP002	20	
73318 ✓	14	
81343	6	

D3536-23 Manufactured No Each 16.0000 1 BR 12-6-4
Gasket

Location	Loc Qty	Loc Code
FP002	16	
74510	1	
83377 ✓	15	

D3536-37 Manufactured No Each 19.0000 1 BR 12-6-4
Gasket

Location	Loc Qty	Loc Code
FP002	19	
66823 ✓	7	
82623	12	

Picklist Print

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Work Order ID: 84476

Parent Item: D206-642-411

Parent Item Name: Skidtube LH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

D3537-1 Manufactured No Each 41.0000

6 *BR 12-6-4.*

Location	Loc Qty	Loc Code
FG <i>84091</i>	10	
79833	10	
FP002 -	31	
69817	5	
81362	22	
83254	1	
83255	3	

6.

D3537-3 Manufactured No Each 28.0000

1 *BR 12-6-4.*

Location	Loc Qty	Loc Code
FP002	28	
78836	5	
81363 ✓	23	

1

MS21042-4 Purchased No Each 1,071.0000

M106051

Location	Loc Qty	Loc Code
ST299	1071	
100743	9	
119124	1000	
5461	1	
6844	19	
7690	24	
8182	6	
9063	8	
9229	4	

Picklist Print

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Work Order ID: 84476

Parent Item: D206-642-411

Parent Item Name: Skidtube LH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

MS21043-4
Nut

Purchased

No

Each 1,546.0000

50 1

Location	Loc Qty	Loc Code
FG	40	
104603	40	
ST301	1506	
119546	185	
121162	821	
121652	500	

MS27039C1-08
SCREW

Purchased

No

Each 1,142.0000

60

BR 12-6-4.

Location	Loc Qty	Loc Code
FP002	1	
116022	1	
ST292	1122	
120308	354	
121068	108	
121162	660	
ST293	19	
116373	3	
118077	14	
119309	2	

60

NAS1149C0332R
Washer

Purchased

No

Each 3,354.0000

60

BR 12-6-4.

Location	Loc Qty	Loc Code
ST297	219	
119736	196	
120648	23	
ST298	3135	
121255	11	
121509	3124	

60.

May-15-12 1:02:43 PM

Shop Packet Print

Page 7

Date: Thursday, 24/04/2008 3:28:56 PM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 38777A
Estimate Number : 10522
P.O. Number :
This Issue : 24/04/2008 S.O. No. :
Prsht Rev. : NC
First Issue : // Type : LANDING GEAR
Previous Run : 36137A
Drawing Name : 206 L HIGH GEAR SKIDTUBE
Part Number : D206642441
Drawing Number : D2650 REV E
Project Number : N/A
Drawing Revision : E
Material :
Due Date : 05/05/2008 Qty: 1 Um: Each
Written By :
Checked & Approved By : SLD 08-4-24
Comment : Est Rev: H 05.10.11 Added D3429-1 per CHG002 KJ/CP/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-441 CHG002

N/A

2.0 D2620 Skidtube, 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2620 Bent Tube 3" OD 32449 SL 8-4-29

3.0 D2647 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2647 Fwd Cap 335475 BE 080430

4.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650: Use aluminum rod. Grind D2647 to fit as required.

A/R Aluminum Rod M106330 BE 08/04/30
M107203

4-Grind weld flush to cap on top surface only. SL 8-5-1

Date: Thursday, 24/04/2008 3:28:56 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 38777A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

5-Cut aft end 138.60" from front of tube

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".

8-Open using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtube as per Dwg D2650

11-Deburr and Blow out all chips from inside the tube

SL 8-5-1

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SL 8-5-1

6.0

D26547

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2654-7

Web

35994

SL 8-5-1

7.0

SKIDTUBES 1

SKIDTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail (without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-7 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs. cure time before cutting

Start Date: 8-5-1 Time: 2:00

Finish Date: 8/5/2 Time: 9:45 AM

A/R Sikaflex-291

107804

Sikaflex expiry date:

8-7-31

SL 8-5-1

Date: Thursday, 24/04/2008 3:28:57 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 38777A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

00/05/02

9.0

D2649

Cross Bolt Spacer



Comment: Qty.: 23.0000 Each(s)/Unit Total: 23.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

23 D2649

Crossbolt spacer

37329

BE 08/05/06

10.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R Aluminum Rod

m107877

BE 08/05/06

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650Deburr

7 SL 8-56

11.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2680-041

Nut Plate

34159A

SL 8-56

12.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 CCR264SS3-3

Rivets

107707

SL 8-56

Date: Thursday, 24/04/2008 3:28:57 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 38777A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

M7885343

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 M7885/3-4-3

Rivets 1025

9L 8-5-6

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

9L 8-5-6

15.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

08/05/06 (40)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/06 (40)

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

FL 08/05/08

18.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White (Ref. 4.3.5.1) as per QSI 005 4.3

Make sure Nut Plate Thread protected use paint screw

M107550

08-05-09

19.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1 08/05/12

20.0

D26483

Wearpad



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description Batch

6 D2648-3

Wearpad 334591

08-05-12 (40)

#4
13 38777A
D 206642441
09/05/2008
S.222 07.50
#1 323.6 F
#2 30m F
#3 30m F

Date: Thursday, 24/04/2008 3:28:57 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 38777A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

D265615

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-15

Wearshoe B34596

JS

22.0

D265623

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-23

Wearshoe B34597

JS

23.0

D265637

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-37

Wearshoe B34510

JS

24.0

D34291

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3429-1

Wearpad B34609

JS

25.0

ALS41032130

Insert



Comment: Qty.: 60.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 ALS4-1032-130

Inserts M105819

or (see QSI 017)

JS 08-05-12 *(X)*

Date: Thursday, 24/04/2008 3:28:57 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 38777A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

AN960JD10L

Washer



Comment: Qty.: 62.0000 Each(s)/Unit Total : 62.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 AN960JD10L

Washer M104885

951

27.0

MS27039108

Screw



Comment: Qty.: 62.0000 Each(s)/Unit Total : 62.0000 Each(s)

Pick:

Qty Part Number

Description Batch

62 MS27039-1-08

Screw M107378

951

28.0

D26511

Plug



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty Part Number

Description Batch

22 D2651-1

Plugs B38273

951

29.0

D26513

O-Ring



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty Part Number

Description Batch

22 D2651-3

O-Rings B36141

951

30.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 AN960JD416

Washer M105426

951

08.05.12

(X1)

Date: Thursday, 24/04/2008 3:28:57 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 38777A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description:

31.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 MS27039-4-06

Screw

M 106541

911

32.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2646

Aft Cap

B336184

911

33.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291

M107804

Sikaflex expiry date:

08/10

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R Sikaflex-291

M107804

Sikaflex expiry date:

08/10

6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4

Batch: M107380

08-05-02

(X1)

34.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/13

Date: Thursday, 24/04/2008 3:28:37 PM
User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	206L/L3/L4 HIGH GEAR SKID
Job Number :	38777		
Estimate Number :	10525		
P.O. Number :		Part Number :	D206642411
This Issue :	24/04/2008	Drawing Number :	N/A
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	//	Drawing Revision :	L
Previous Run :	34568	Material :	
Written By :		Due Date :	05/05/2008
Checked & Approved By :	JLD 08.4.24	Qty:	1 Um: Each
Comment :	Est Rev:K 05.10.11 Revised picklist per CHG004 KJ/CP/JLM Est Rev:L 07-12-04 ECN 1080p DD verified by:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-411 CHG004

JLD 08.4.28
08/06/18

2.0	38777A	206 L HIGH GEAR SKIDTUBE
-----	--------	--------------------------



Comment: Sub-Component 206 L HIGH GEAR SKIDTUBE

D206-642-441 B 38777A

3.0	PACKAGING-1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0	D206648011	GHW Modification
-----	------------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GHW Modification Kit

Batch: 36140

5.0	D2652	Bushing
-----	-------	---------



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 D2652 Bushing

1 D206-642-441(REF)

38777A
38777A

10/04/16 (1)

Date: Thursday, 24/04/2008 3:28:37 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4 HIGH GEAR SKID

Job Number: 38777

Part Number: D206642411

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 D2655 Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2655 Tow Ring B34613

7.0 D2712 Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

10 D2712 Set Screw B34628

8.0 D29321 Saddle LH Out, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2932-1 Saddle 36874

9.0 D29331 Saddle LH In, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2933-1 Saddle B39773

10.0 D2934 Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2934 Saddle Spacer 37368

11.0 D2935 Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2935 Saddle Spacer 37867

Date: Thursday, 24/04/2008 3:28:37 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4 HIGH GEAR SKID

Job Number: 38777

Part Number: D206642411

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D29381

Saddle LH Out, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2938-1

Saddle

34603

13.0

D29391

Saddle LH In, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2939-1

Saddle

34632

14.0

D2968043

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2968-043

Tow Ring

B37380

15.0

AN341A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN3-41A

Bolt

M107242

16.0

AN45A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 AN4-5A

Bolt

M106242

Date: Thursday, 24/04/2008 3:28:37 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L/L3/L4 HIGH GEAR SKID

Job Number: 38777

Part Number: D206642411

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

AN46A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

12 AN4-6A

Bolt

M106662

lu

18.0

AN511A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN5-11A

Bolt

M125812

lu

19.0

AN512A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

AN5-12A

Batch:

M104885

lu

20.0

AN513A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

batch

M104936

lu

21.0

AN960JD10

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN960JD10

Washer

M107715

lu

22.0

AN960JD1016

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Qty Part Number

Description Batch

1 AN960JD1016

Washer

M5819

lu 8/0/170

Date: Thursday, 24/04/2008 3:28:37 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4 HIGH GEAR SKID

Job Number: 38777

Part Number: D206642411

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

AN960JD416

Washer



Comment: Qty.: 25.0000 Each(s)/Unit Total : 25.0000 Each(s)

Qty Part Number

Description Batch

25 AN960JD416

Washer M127321

24.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Qty Part Number

Description Batch

8 AN960JD516

Washer M127534

25.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Qty Part Number

Description Batch

1 AN970-4

Washer M127242

26.0

MS21042L3

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Qty Part Number

Description Batch

8 MS21042L3

Nut (or -3) M127644

27.0

MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Qty Part Number

Description Batch

13 MS21042L4

Nut (or -4) M126005

28.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

PC 907/13 ①
508661/8 @

Date: Thursday, 24/04/2008 3:28:37 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L/L3/L4 HIGH GEAR SKID

Job Number: 38777

Part Number: D206642411

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

PACKAGING 1

PACKAGING RESOURCE #1



(1x)

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-411

Location: _____

PPP Rev: _____

Rev D

8/6/18

Sy

30.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/19

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08-06-18

Part Number D206-642-411
Description 206 SKIDSTEER INSTALLATION

Page 1 of 1

Chg.	Date	By	Relevant Documents
1	98.12.14	DS	MDL - D206-642 REV. I
2	99.04.28	DS	- MDL - D206-642 REV. J - ADDED SADDLE SPACERS PER DSI 91SD REV.A - D265S TOW RING SHIPPED LOOSE RATHER THAN INSTALLED ON SKIDTUBE
3	00.03.14	DS	CHANGE TO D2968-043 TOW RING PER DSI 91B1 REV.A
4	05.10.04	CP	Add D3475-1 MDL - D206-642 Rev O
005	08.10.07	JG	DSI 9421 Rev. A, D2650 Rev. F (ECN 08-538)
006	09.02.19	JG	DSI 9421 Rev. B, DSI 9440 Rev. A, D206-648 Rev B, D3411 Rev. B (ECN 09-53)

✓ 84474 - 38778

✓ 84475 - 34556

✓ 84476 - 38777

✓ 84477 - 34560

ENGINEERING CHANGE NOTICE **DART AEROSPACE LTD**

Date: 09.02.18	Job No.: 00569	ADR Yes/No: N	ADR Date:	ECN #: 09- 531
Product No.: D206-642		Created By: AJS	Approved By: <i>[Signature]</i>	
Product Name: Skidbte Installation		Checked By: <i>[Signature]</i>	General Manager Approval:	

Distribution	Reqd	Resp	Initial / Date
Production Manager	Y	LL	<i>11/09/02/19</i>
Production Engineering Coord	Y	EC/DD	<i>11/09/02/19</i>
Production Document Control	Y	JLD	<i>11/09/02/19</i>
Customer Technical Support			

Distribution	Reqd	Resp	Initial / Date
DQA / QA Coord			
QC Coordinator	Y	JM	<i>10/09/02/19</i>
Marketing	Y	SW	<i>8/09/03/19</i>
Customer Order Processing			

Reason for Change: DESIGN IMPROVEMENT CHANGE FROM CARBON STEEL TO STAINLESS STEEL

Documents Affected:

DSI 9421 REV B
DSI 9440 REV A
D206-648 REV B
D3414 Rev B

PARTS MUST COMPLY ☐

PREVIOUS PARTS SATISFACTORY ☒

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	Y	KJ		<i>09.02.19</i>
5	Update Product Compatability Matrix	N			
6	Create Eurocopter Form (FEE)	N			
7	Notify TC / FAA of Change	N			

#	Document Control Actions	Reqd	Resp	Notes	Complete
8	Move Electronic Files	Y	KJ		<i>09.02.19</i>
9	Update Blue/Pink/DSI Folder and Electronic Files	Y	KJ		<i>09.02.19</i>
10	Update Controlled PDF Files	Y	KJ		<i>09.02.19</i>
11	Update Master Document List (MDL)	Y	AJS	<i>Rev. U</i>	<i>09.02.19</i>
12	Update Document Record (DR)	Y	KJ		<i>09.02.19</i>
13	Update Product Development Summary	N			
14	Update QSI 021 and/or STC Approval List	N			
15	Update Parts / STC Database	N			
16	Update / Verify ARC Database	N			
17	Create / Update Change Record Form	Y	KJ	<i>SEE BELOW</i>	<i>09.02.19</i>
18	Create / Update PPP's	Y	KJ		<i>09.02.19</i>
19	Update Document Control Database / Laminated Dwgs	N			
20	Update Grey Project Binder	Y	KJ		<i>09.02.19</i>
21	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		<i>09.02.19</i>
22					
23					

Description / Action:

Roll -111/-112/-211/-212/-213/-214 to Change number 005 (Per DSI 9421)

-141/-241 @ CHG 004, -143/-243 @ CHG 002 (PER DSI 9440 Rev. A)

Roll -311/-312/-411/-412 To Change number 006 (Per DSI 9421)

-341/-441 @ CHG 003, -443 @ CHG 001, 343 @ CHG 002 (PER DSI 9440 Rev. A)

Previous parts Disposition: Deplete existing stock of -111/-112/-211/-212/-213/-214 parts @ Change 004 respectively. DO NOT mix parts from change 004 and change 005

Previous parts Disposition: Deplete existing stock of -311/-312/-411/-412 parts @ Change 005 DO NOT mix parts from change 005 and change 006

D206-648-011/-013 NOW AT CHG002 (D206-648 Rev. B) - DO NOT MIX PARTS

ECN Verified & Complete: *[Signature]*

Date: *09/03/16*

ENGINEERING CHANGE NOTICE **DART AEROSPACE LTD**

Date: 09.02.18	Job No: 00569	ADR Yes/No: N	ADR Date: 09.02.19	ECN #: 09- 531
Product No.: D206-642	Created By: AJS	Approved By: [Signature]		
Product Name: Skidbe Installation	Checked By: [Signature]	General Manager Approval:		

Distribution	Reqd	Resp	Initial / Date
Production Manager	Y	LL	
Production Engineering Coord	Y	EC/DD	09/02/19
Production Document Control	Y	SLD	09.02.19
Customer Technical Support			

Distribution	Reqd	Resp	Initial / Date
DQA / QA Coord			
QC Coordinator	Y	JM	09.02.19
Marketing	Y	SW	
Customer Order Processing			

Reason for Change: DESIGN IMPROVEMENT CHANGE FROM CARBON STEEL TO STAINLESS STEEL

Documents Affected:
 DSI 9421 REV B
 DSI 9440 REV A
 D206-648 REV B
 D3414 Rev B

☒ PARTS MUST COMPLY
 ☐ PREVIOUS PARTS SATISFACTORY

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	Y	KJ		09.02.19
5	Update Product Compatability Matrix	N			
6	Create Eurocopter Form (FEE)	N			
7	Notify TC / FAA of Change	N			

#	Document Control Actions	Reqd	Resp	Notes	Complete
8	Move Electronic Files	Y	KJ		09.02.19
9	Update Blue/Pink/DSI Folder and Electronic Files	Y	KJ		09.02.19
10	Update Controlled PDF Files	Y	KJ		09.02.19
11	Update Master Document List (MDL)	Y	AJS	Rev. U	09.02.19
12	Update Document Record (DR)	Y	KJ		09.02.19
13	Update Product Development Summary	N			
14	Update QSI 021 and/or STC Approval List	N			
15	Update Parts / STC Database	N			
16	Update / Verify ARC Database	N			
17	Create / Update Change Record Form	Y	KJ	SEE BELOW	09.02.19
18	Create / Update PPP's	Y	KJ		09.02.19
19	Update Document Control Database / Laminated Dwgs	N			
20	Update Grey Project Binder	Y	KJ		09.02.19
21	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		09.02.19
22					
23					

Description / Action:

Roll -111/-112/-211/-212/-213/-214 to Change number 005 (Per DSI 9421)
 -141/-241 @ CHG 004, -143/-243 @ CHG 002 (PER DSI 9440 Rev. A)
 Roll -311/-312/-411/-412 To Change number 006 (Per DSI 9421)
 -341/-441 @ CHG 003, -443 @ CHG 002 (PER DSI 9440 Rev. A)
 Previous parts Disposition: Deplete existing stock of -111/-112/-211/-212/-213/-214 parts @ Change 004 respectively. DO NOT mix parts from change 004 and change 005

Previous parts Disposition: Deplete existing stock of -311/-312/-411/-412 parts @ Change 005 DO NOT mix parts from change 005 and change 006

D206-648-011/-013 NOW AT CHG002 (D206-648 REV. B) -DO NOT MIX PARTS

N/A
JW 09.03.03

ECN Verified & Complete: _____

Date: _____

4.4 206L/L-1/L-3/L-4 High Gear Skidtubes (D206-642)
32.13 206L/L-1/L-3/L-4 High Gear Skidtubes (ICA-D206-642)

IS:

ITEM	Qty -411	Qty -412	Qty -441	Qty -443	Qty -013	PART NUMBER	DESCRIPTION
	X					D206-642-411	SKIDTUBE INSTALLATION, LH
		X				D206-642-412	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-441	SKIDTUBE
				X		D206-642-443	WEARSHOE KIT
	1	1			X	D206-648-013	GROUND HANDLING KIT
30	1	1				D3407-043	TOW RING ASSEMBLY
32A	1	1				D3456-1	WASHER
32B	2	2				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34	1	1				AN4C5A	BOLT
35	1	1				AN960C416	WASHER
36	1	1				D3413-1	RING
40					2	D3414-041	LUG ASSEMBLY
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER

WAS:

ITEM	Qty -411	Qty -412	Qty -441	Qty -443	Qty -011	PART NUMBER	DESCRIPTION
	X					D206-642-411	SKIDTUBE INSTALLATION, LH
		X				D206-642-412	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-441	SKIDTUBE
				X		D206-642-443	WEARSHOE KIT
	1	1			X	D206-648-011	GROUND HANDLING KIT
30	1	1				D2707-043 (OR D2968-043)	TOW RING
31	1	1				AN960JD1016	WASHER
32	1	1				AN970-4	WASHER
33	1	1				MS21042-4	NUT (OR MS21042L4)
34	1	1				AN4-5A	BOLT
35	1	1				AN960JD416	WASHER
36	1	1				D2655	RING
40					2	D2659	GHW LUG
41					4	AN3-37A	BOLT
42					8	D2652	BUSHING
43					4	MS21042-3	NUT (OR MS21042L3)
44					4	AN960DJ10	WASHER

DESIGN	AJS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9421	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE INSTALLATIONS	NTS
DATE	08.10.07	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	

4.3 206 L/L-1/L-3/L-4/407 Low Gear & 407 High Gear Skid tubes (D206-642)
 32.12 206 L/L-1/L-3/L-4/407 Low Gear & 407 High Gear Skid tubes (ICA-D206-642)

ITEM	Qty -311	Qty -312	Qty -341	Qty -347	Qty -013	PART NUMBER	DESCRIPTION
	X					D206-642-311	SKIDTUBE INSTALLATION, LH
		X				D206-642-312	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-341	SKIDTUBE
				X		D206-642-347	WEARSHOE KIT (REPLACES -343)
	1	1			X	D206-648-013	GROUND HANDLING KIT

IS:

20A			6			D3537-1	WEARPAD (REPLACES D2648-3)	(MODIFY)
21A			1			D3537-3	WEARPAD (REPLACES D3429-1)	(MODIFY)
22A			1	1		D3535-11	WEARSHOE (REPLACES D2656-11)	(MODIFY)
22B			1	1		D3536-11	GASKET	(ADD)
23A			1	1		D3536-23	WEARSHOE (REPLACES D2656-23)	(MODIFY)
23B			1	1		D3536-23	GASKET	(ADD)
24A			1	1		D3535-35	WEARSHOE (REPLACES D2656-35)	(MODIFY)
24B			1	1		D3536-35	GASKET	(ADD)
26A			54			MS27039-1C08	SCREW	(MODIFY)
26B			54			AN960C10L	WASHER	(MODIFY)

WAS:

20A			6			D2648-3	WEARPAD
21A			1			D3429-1	WEARPAD
22A			1	1		D2656-11	WEARSHOE
23A			1	1		D2656-23	WEARSHOE
24A			1	1		D2656-35	WEARSHOE
26A			54			MS27039-1-08	SCREW
26B			54			AN960JD10L	WASHER

4.4 206L/L-1/L-3/L-4 High Gear Skid tubes (D206-642)
 32.13 206L/L-1/L-3/L-4 High Gear Skid tubes (ICA-D206-642)

ITEM	Qty -411	Qty -412	Qty -441	Qty -447	Qty -013	PART NUMBER	DESCRIPTION
	X					D206-642-411	SKIDTUBE INSTALLATION, LH
		X				D206-642-412	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-441	SKIDTUBE
				X		D206-642-447	WEARSHOE KIT (REPLACES -443)
	1	1			X	D206-648-013	GROUND HANDLING KIT

IS:

20A			6			D3537-1	WEARPAD (REPLACES D2648-3)	(MODIFY)
21A			1			D3537-3	WEARPAD (REPLACES D3429-1)	(MODIFY)
22A			1	1		D3535-15	WEARSHOE (REPLACES D2656-15)	(MODIFY)
22B			1	1		D3536-15	GASKET	(ADD)
23A			1	1		D3536-23	WEARSHOE (REPLACES D2656-23)	(MODIFY)
23B			1	1		D3536-23	GASKET	(ADD)
24A			1	1		D3535-37	WEARSHOE (REPLACES D2656-37)	(MODIFY)
24B			1	1		D3536-37	GASKET	(ADD)
26A			60			MS27039-1C08	SCREW	(MODIFY)
26B			60			AN960C10L	WASHER	(MODIFY)

WAS:

20A			6			D2648-3	WEARPAD
21A			1			D3429-1	WEARPAD
22A			1	1		D2656-15	WEARSHOE
23A			1	1		D2656-23	WEARSHOE
24A			1	1		D2656-37	WEARSHOE
26A			60			MS27039-1-08	SCREW
26B			60			AN960JD10L	WASHER

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	---	DRAWING NO.	REV. 3
MFG. APPR.	N/A	DSI 9440	SHEET 3 OF 4
APPROVED	---	TITLE	SCALE
DE APPR.	---	WEARSHOE CHANGE	NTS
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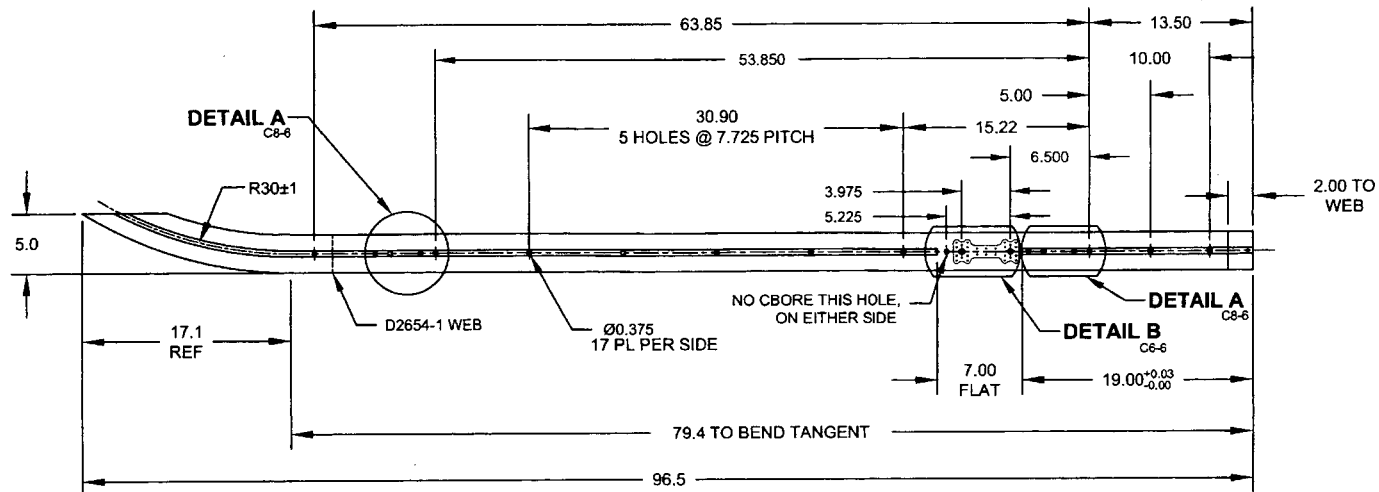
QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

NOTES:

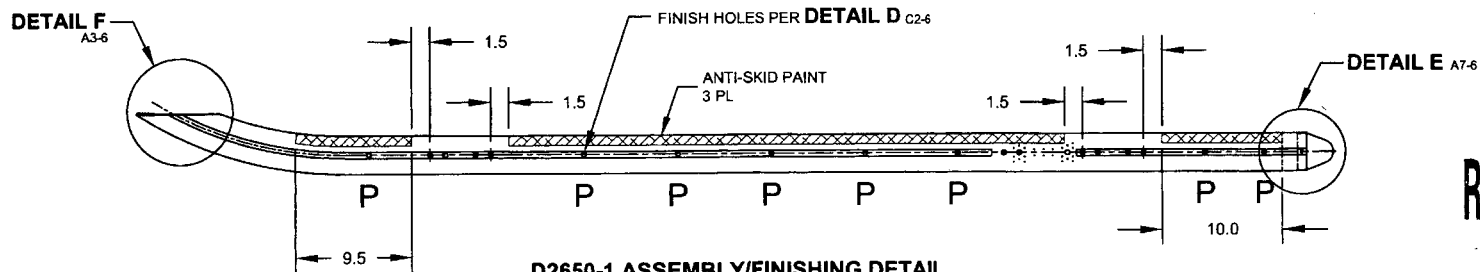
- MATERIAL: N/A
- FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- IDENTIFICATION: NONE
- WEIGHT: N/A
- WELD PER DART QSI 004
- DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- INSERT D2651-1 PLUG CW D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
08-07-23/17

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCORP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
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DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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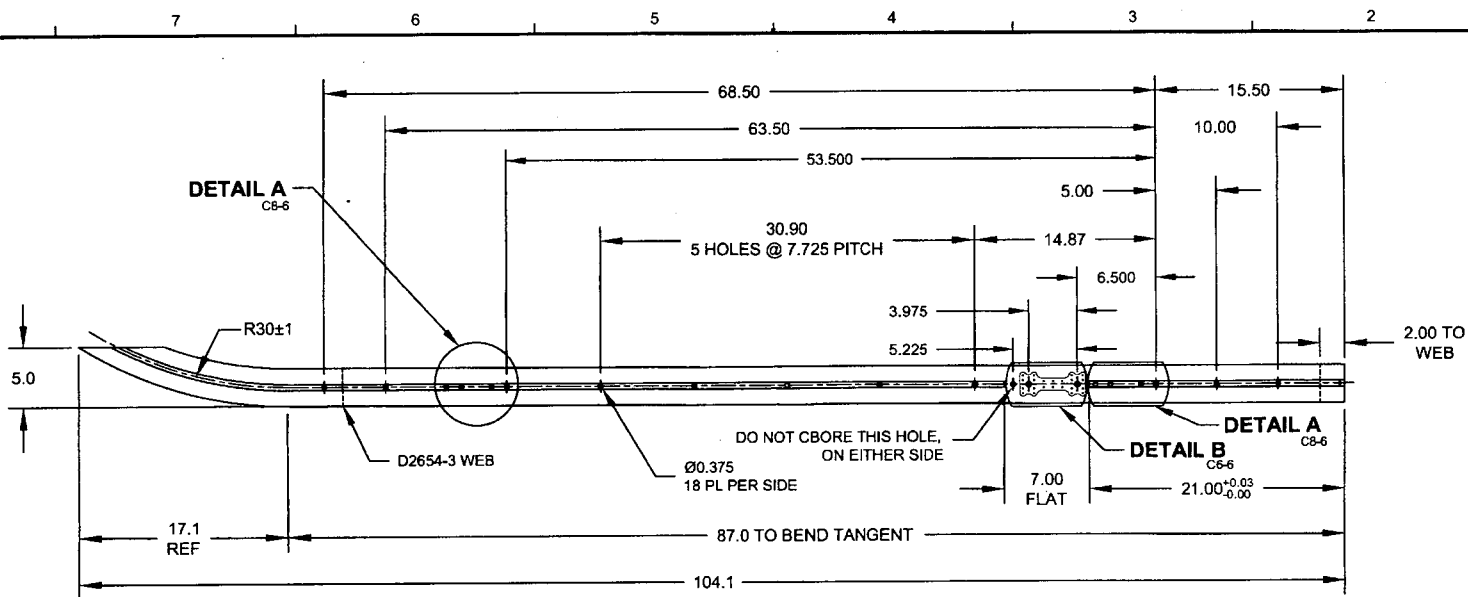
D2650-1 BENDING/DRILLING DETAIL



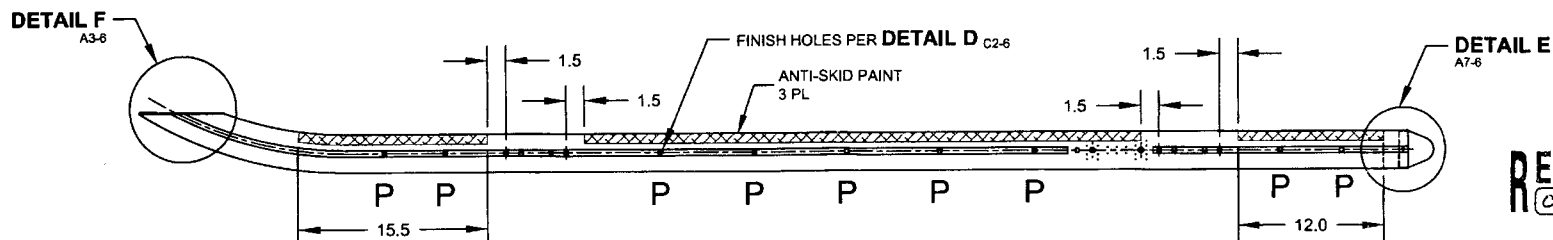
D2650-1 ASSEMBLY/FINISHING DETAIL

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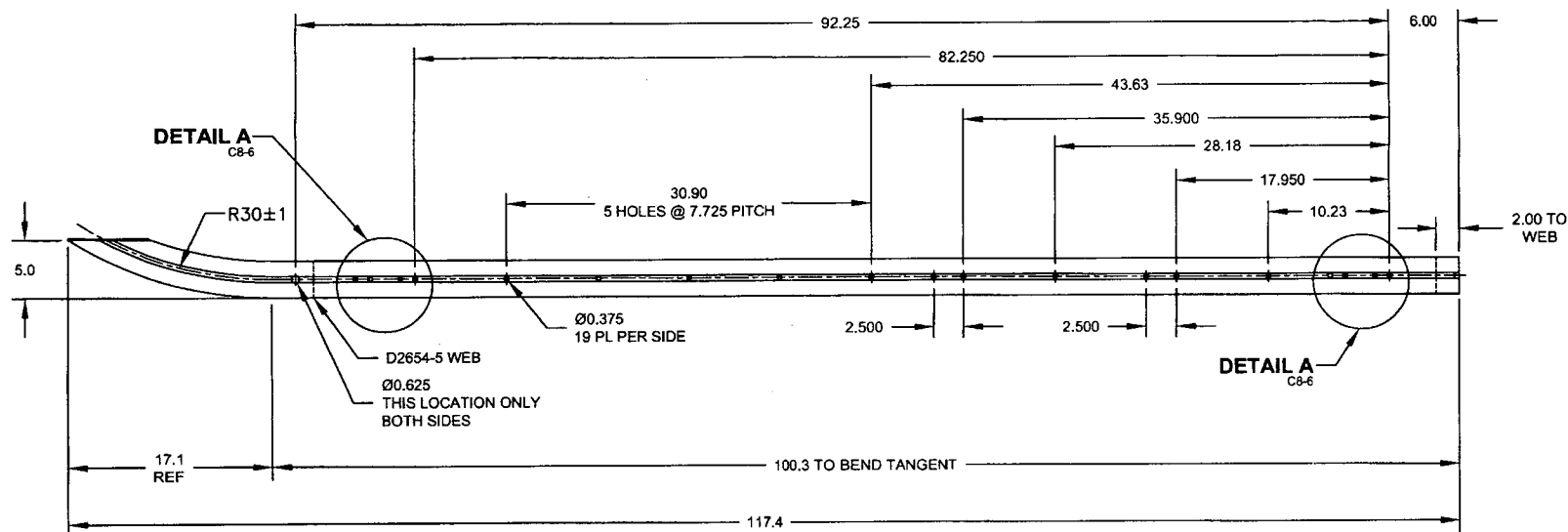
D2650-3 BENDING/DRILLING DETAIL



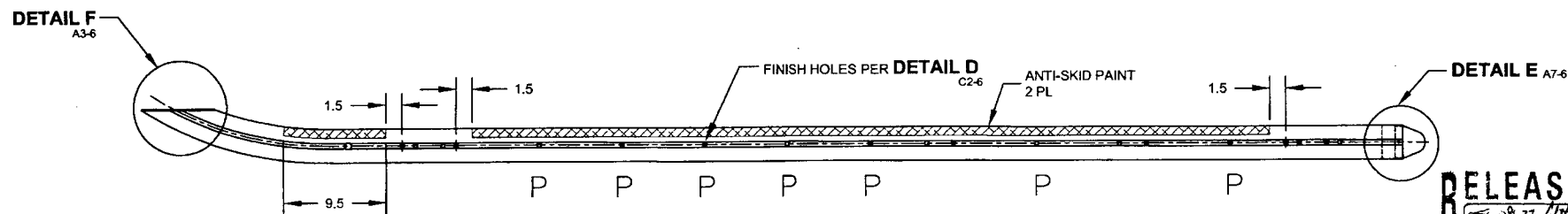
D2650-3 ASSEMBLY/FINISHING DETAIL

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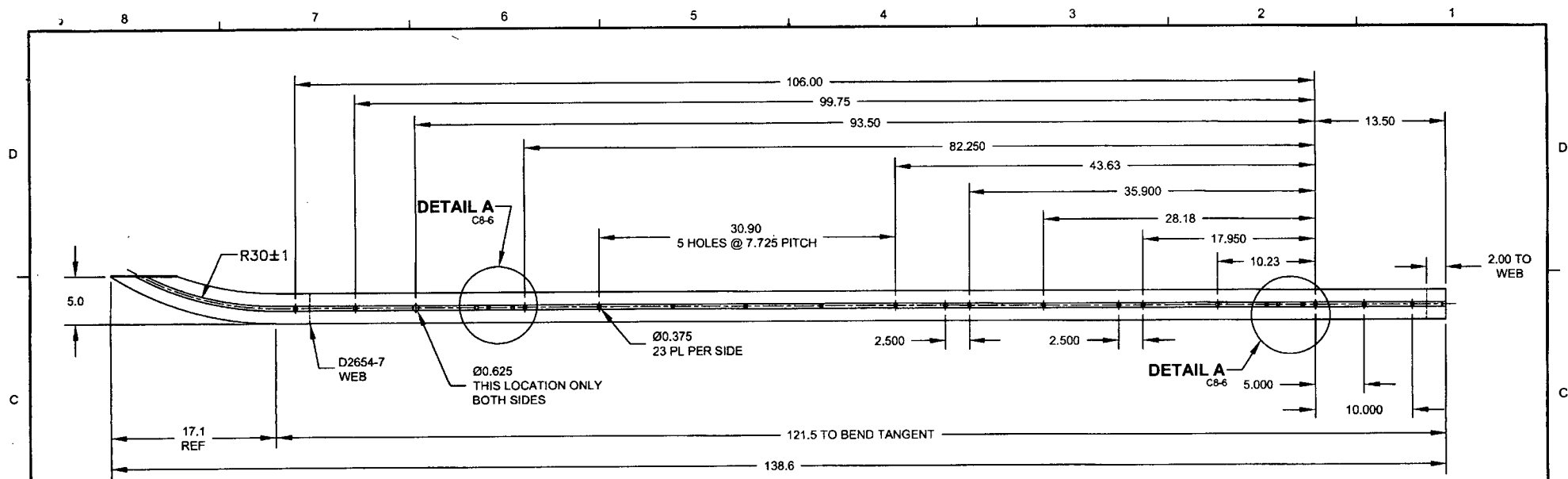
D2650-5 BENDING/DRILLING DETAIL



D2650-5 ASSEMBLY/FINISHING DETAIL

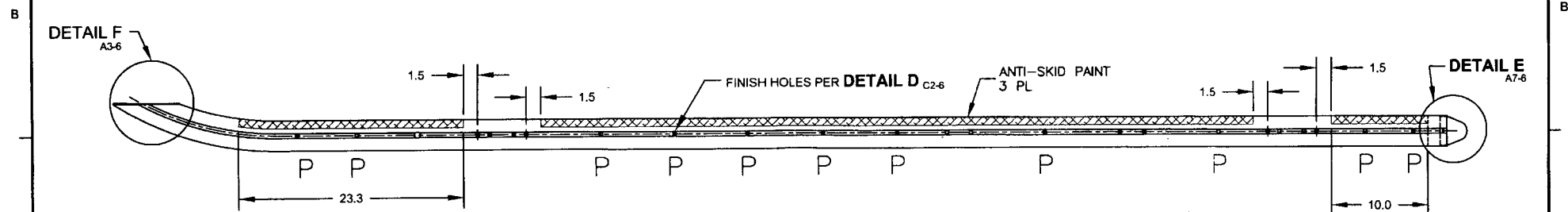
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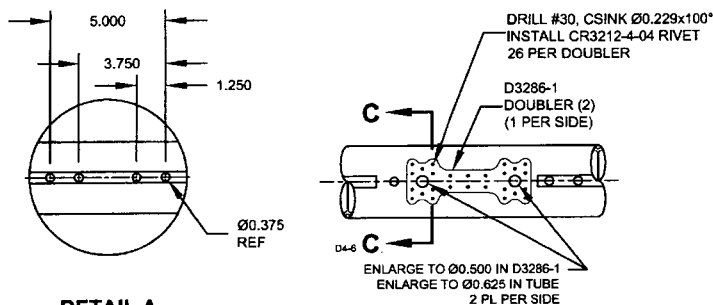
D2650-7 BENDING/DRILL DETAIL

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D2650-7 ASSEMBLY/FINISHING DETAIL

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DETAIL A
SCALE 2X

C2-2
D7-2
C2-3
D7-3
C2-4
D7-4
C2-5
D6-5

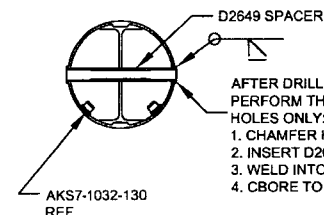
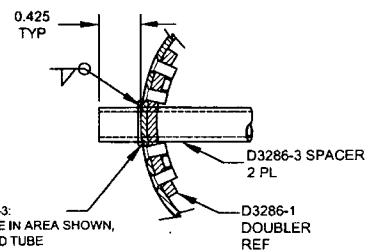
DETAIL B
SCALE 2X

C3-2
C3-3

- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE.



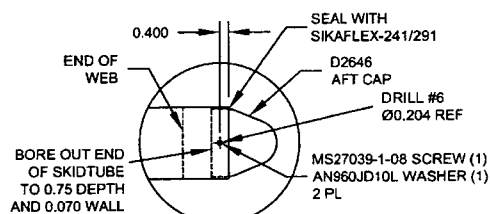
SECTION C-C
SCALE NONE



DETAIL D
FOR Ø0.375 HOLES ONLY
SCALE 3X

B4-2
B4-3
B4-4
B4-5

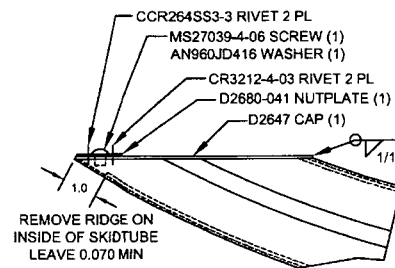
- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP



DETAIL E
SCALE 2X

B2-2
B2-3
B1-4
B1-5

ORIENTATION OF
D2680-041



DETAIL F
SCALE NONE

B9-2
B8-3
B8-4
B8-5

DETAIL F NOTES:

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

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